<b>Work Order ID 59473</b> Friday, June 04, 2010 2:45:27 PM											Page 1
Item ID: Revision ID: Item Name: Start Date: Required Date:	D3999-041  Baffle Assemb	oly, Aft  Start Qty: 1.00  Req'd Qty: 1.00		Accept	Cust Item II	<b>                                     </b>		s s		tart	
Reference: Approvals:	Process Pla		Date/O-C-O	Tooling: SPC (Y/N):	Customer: Da			F		tart	
Sequence ID/ Work Center II Draw Nbr		Operation Description ision Nbr		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Rejec Numb	
D3999  100  Waterjet  FLOW CNC Waterje	A et	Memo C: 1-Cut as per Dwg Rev: Prog Rev: 2-Deburr if	<u>*</u>	0.00 0.00 0.00	r			IB (C	s 6-6		
110 QC Quality Control		QC2- Inspect parts off m	achine FAI/FAIB	0.00				V3.10	>-6- «	1	- <del></del>

\$

### **Dart Aerospace Ltd** W/O: **WORK ORDER CHANGES Approval** DATE **STEP PROCEDURE CHANGE Approval** Ву Qty Date Chief Eng / QC Inspector Prod Mar £. Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: Date: \_\_\_\_\_ Resolution: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_\_ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification DATE **STEP Approval Approval** Initial **Action Description** Sign & Section A Section Chief Ena QC Inspector Chief Eng Chief Eng Date

# Work Order ID 59473

Friday, June 04, 2010 2:45:27 PM



Page 2

Item ID:

D3999-041

Accent

Setup Start

Stop



Revision ID:

Item Name: Baffle Assembly, Aft

**Required Date: 6/10/2010** 

Start Date:

6/4/2010

Start Oty: 1.00

Reg'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

0.00

0.00

Date:

Run Start

Stop



OC:

Date: \_\_\_\_\_

SPC (Y/N):

Tool # Plan Code

Accept

Reject

Reject Insp.

**Work Center ID** 

Sequence ID/

120

OC

Quality Control

Operation Description

OC8- Inspect parts - second check

Memo

Set Up/ **Run Hours** 

01001016

Tool ID

Date:

Qty

Otv

Number Stamp

130

Brake NC

Brake NC

Bend as per dwg

Memo Bend D3999-1 as per Dwg 0.00

0.00

Sos coloulas

180

Small Fab

Small Fab

Memo

Assemble as per dwg

0.00

0.00

9010/06/30 Q

Dart Ae	rospace Lt	d							
W/O:			WC	ORK ORDER CHANGE	S	·			ı ,
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty Approv		Approv
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Part No	):	PAR #:	Fault Cate	norv:	NCP: Voc	No. DOA:		Doto	
		olution:							
NCR:				ER NON-CONFORMAI					
		Description of NC		Section B				A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verifica Section		Approval Chief Eng	Approva QC Inspect
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							-		

## Work Order ID 59473

Friday, June 04, 2010 2:45:27 PM



Page 3

Item ID:

D3999-041

Accept

Setup Start



**Revision ID:** 

Item Name:

Baffle Assembly, Aft

**Start Date:** 

6/4/2010

Start Qty: 1.00

**Required Date:** 6/10/2010 Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date:

Tooling:

Date:

Run

Start

Stop

Stop



Date:\_\_\_\_\_

**SPC (Y/N):** 

Tool ID

Tool # Plan '

Accept Reject Reject Insp.

**Work Center ID** 

190

Sequence ID/

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours** 

8 10/06/30

Date:

Qty Qty

Number Stamp

Quality Control

Memo

Code

200

Packaging

Packaging

Identify as per dwg & Stock Location: \_\_/ 3

Memo

0.00

0.00

210

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

mx 10-7-01

rospace Li	td							
		WO	RK ORDER CHANGES	3				
STEP	PROCEDURE CHANGE B				Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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Reso	olution:	Disposition	n:	QA: N/C CI	osed:	ļ	Date: _	
		WORK ORDE	R NON-CONFORMAN	CE (NCR	)			
STED	Description of NC		Corrective Action Section B		Verifica	cation Approva	Approval	l Approva
JILI	Section A	Initial Chief Eng	Action Description  Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspect
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# **Picklist Print**

Friday,\*June 04, 2010 2:45:31 PM

Work Order ID: 59473

Parent Item:

D3999-041

Parent Item Name:

Baffle Assembly, Aft

Comments:

IPP rev A 09.12.16 new issue Prelim EC verified by:DD IPP rev B

10.05.10 ecn 10-562 EC verified by:DD



Start Date: 6/4/2010

**Required Date: 6/10/2010** 

Start Oty: 1.00

Required Oty: 1.00

Component Item ID/ Item Name M6061T6S.063

Replacement Mfg/ Item ID Purch Purchased

Item No

Primary Location Last Route Location Seq ID 100

sf

Unit of Oty on Hand Measure 130 7000

Oty per Kit Total 2.27

Issued Otv 2.389474

Oty

1810-69

Date Status

Page 1

Issued

6061-T6 .063 Sheet

Location

MAT21 113608 Loc Otv 130.7

130.7

Each

Loc Code

113608

D3999-5

Angle

Manufactured

No

No

180

180

Each

0.0000

1,860,000

Purchased

Rivet, Universal Head

MS20470AD4-4

Location Loc Qty ST319 122 112314 30 113368 92 ST321 1738 114761 1738 Loc Code

Dart Ae	rospace L	td							•
W/O:			WC	ORK ORDER CHANGES	3				,
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approv
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DATE	STEP Description of NC			В	Verifica	fication	Approval	Approva	
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspect
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									<u> </u>

DART AEROSPACE LTD	Work Order:	59473
DART AEROSPACE ETD		
Description: BARLE ASSEMBLY	Part Number:	D3999-041
Inspection Dwg: D3QCPI-( Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X First Art	icle	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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3.37	14 .330	3.275	4			
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5.02	4 .030	5,030	*			
6.77	4 .030	6,771	<del>\</del>	ļ	<u>                                     </u>	
7.58	1/030	7.578	>			

Measured by: 12	Audited by:	8	Prototype Approval:	N/A
Date: 10-6-9	Date:	0,,	Date:	N/A
		•	•	

1	D	Data	Change	Revised by	Approved
-	Rev	Date	Change	KJ/JLM	1
	Α		New Issue	KOJOLIVI	<del></del>

DART AEROSPACE LTD	Work Order:	59473
Description: BAFLE ASSEMBLY	Part Number:	D3999-041
Inspection Dwg:D3949-1 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

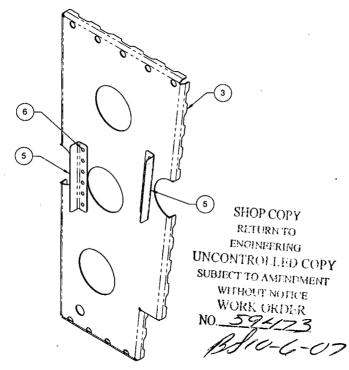
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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Measured by: 12	Audited by:	Prototype Approval:	N/A
	Date: 10 00 10	Date:	N/A
Date: 10-6-9	1000110		

	D-4-	Change Revised by	Approved
Rev	Date	KJ/JLM	
Α		New Issue	<u></u>

				•	5
ITEM NO.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	Х		D3999-041	BAFFLE ASSEMBLY, AFT	JCA-M47-1-02
2		X	D3999-043	BAFFLE ASSEMBLY, FWD	JCA-M47-1-03
3	1		D3999-1	BAFFLE	
4		1	D3999-3	BAFFLE	
5	2	2	D3999-5	ANGLE	
6	12	12	MS20470AD4	RIVET	



D3999-041 BAFFLE ASSEMBLY, AFT



- NOTES:
  1) MATERIAL: N/A
  2) FINISH: N/A
  3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  4) UNITS: INCHES UNLESS OTHERWISE NOTED
  5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3999-041/-043" AND B/N USING FINE POINT PERMANENT INK MARKER
  7) WEIGHT (-041): 1.51 lbs
  8) WEIGHT (-043): 1.84 lbs

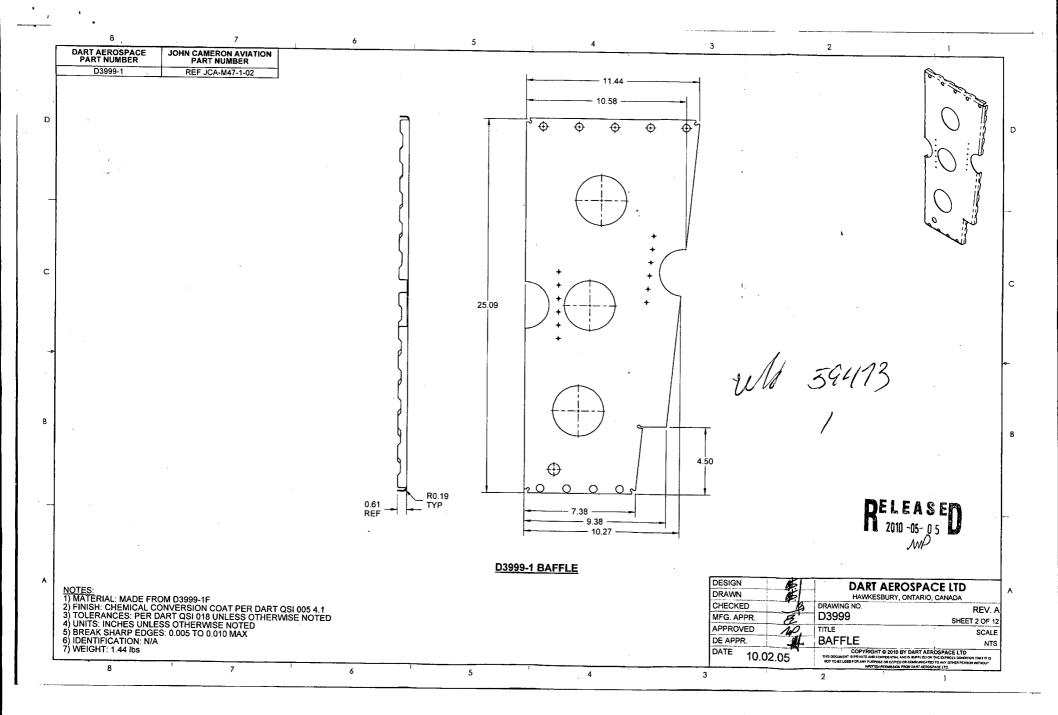
### D3999-043 BAFFLE ASSEMBLY, FWD

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REV.			DESCRIPTION	BY	DATE		
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CHECK		B	DRAWING NO.		REV. A		
APPRO		10	TITLE		SHEET 1 OF 12 SCALE		
DE APP	PR.	#	BAFFLE		NTS		
DATE	10.0	2.05	THIS DOCUMENT IS PRIVATE AND COMPID NOT TO BE USED FOR ANY PURPOSE OR	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPORTED AND IS EMPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED ON COMMENCENTED TO ANY OTHER PERSON WITHOUT WINDTETH PERSONS OF FOOD ORAT AEROSPACE CTD.			
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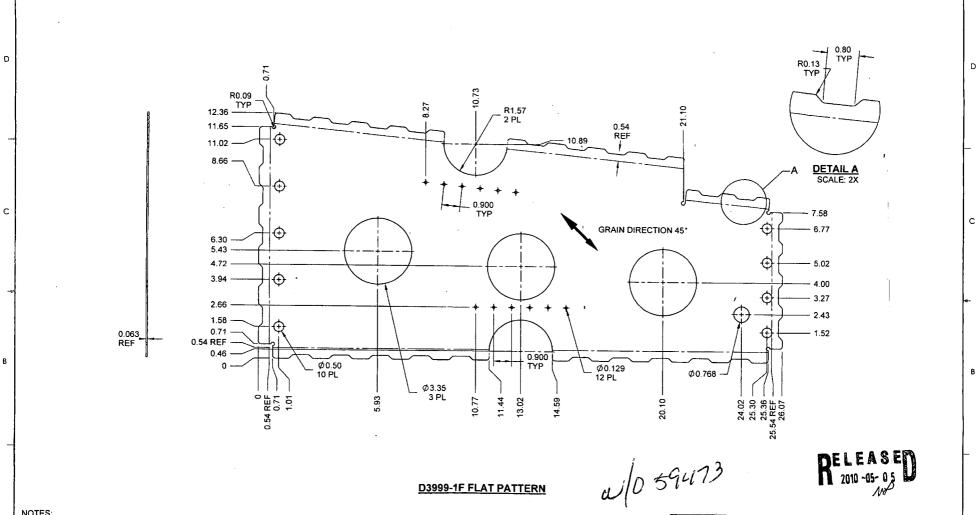
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Part No	•	PAR #:	Fault Cate	egory:	NC	R: Yes	No <b>DQA</b> :		_ Date: _	
Resolution: Disposition: QA: N/C Closed: NCR: WORK ORDER NON-CONFORMANCE (NCR)				Date: _						
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DATE	STEP	Description of NC			ction B		Verifica	ion	Approval	Approval
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Dart Ae	rospace	Ltd						•••	, , • ' ,	
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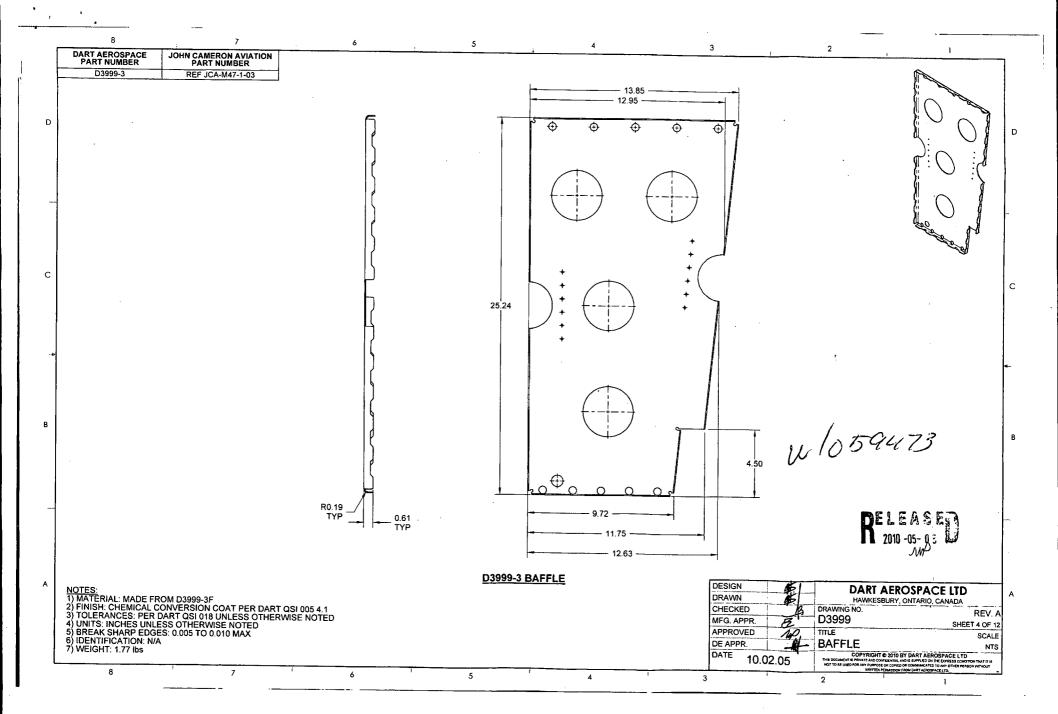
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	HAWKESBURY, ONTA	45	DRAWN
REV. A	DRAWING NO.	B	CHECKED
SHEET 3 OF 12	D3999	E	MFG. APPR.
SCALE	TITLE	10	APPROVED
NTS	BAFFLE	-#	E APPR.
RT AEROSPACE LTD	COPYRIGHT @ 2010 BY DAR	05	TE 10.0

NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF DART SPEC M6061T6S.063

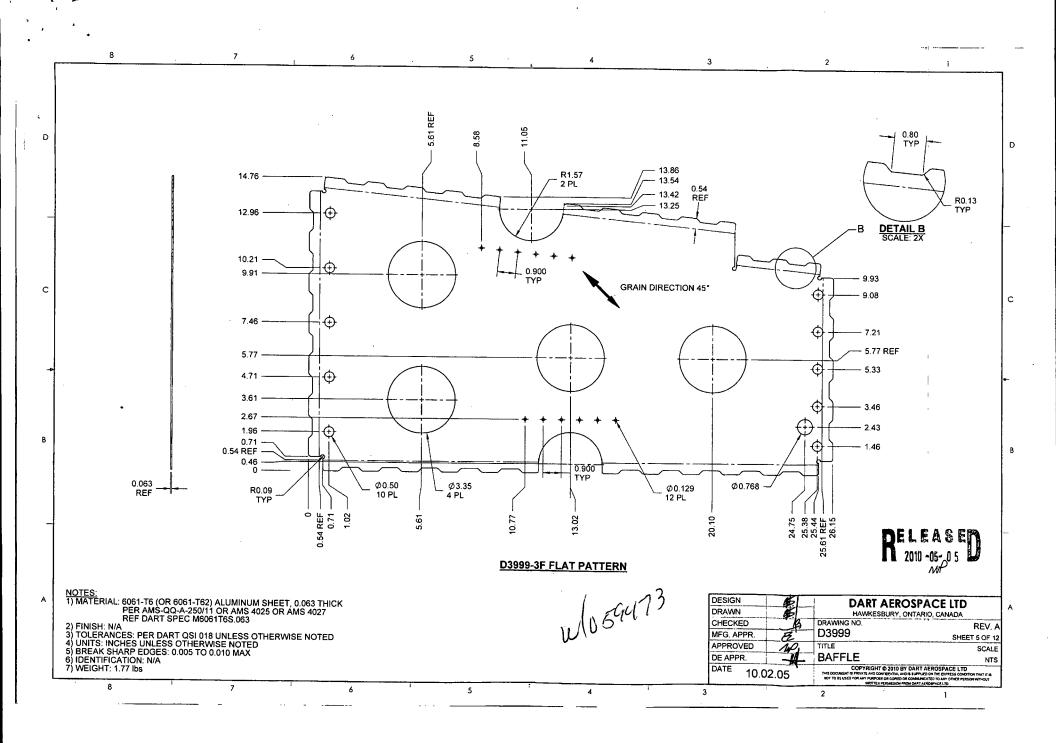
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A 7) WEIGHT: 1.44.lbs

Dart Ae	rospace L	td							~ .
W/O:			WC	RK ORDER CHANGE	S				, i
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date (	ty	Approval Chief Eng / Prod Mgr	Approva QC Inspect
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# Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng/ Prod Mgr OC Inspector Approval OC Inspector

Part No:	PAR	#: Fault Categ	Jory: NCR: Yes	No DQA: D	Date:
R	esolution:	Disposition	n: QA: N/C CI	osed: C	Date:

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		Description of NC	+	Corrective Action Section B		Verification	Ammunual	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC inspector
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		•						}-

5 DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER REF JCA-M47-1-02 REF JCA-M47-1-03 D3999-5 D 0.83 С 5.50 REF 0.83 R0.12 REF **D3999-5 ANGLE** WW 59473 DESIGN NOTES:
1) MATERIAL: MADE FROM D3999-5F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN CHECKED DRAWING NO. REV. A D3999 MFG. APPR. SHEET 6 OF 12 APPROVED TITLE SCALE DE APPR. **BAFFLE** SAFFLE

DOPYRIGHT © 2010 BY DART AEROSPACE LTD

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W/O:			W	ORK ORDER CHANGE	ES				
DATE	STEP				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
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		Description of NC		Corrective Action Section	n B	Verifica	lan	Approval	Approval QC Inspector
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	Verification Section C	Approval Chief Eng	

3 2 D R0.20 TYP BEND LINE-GRAIN DIRECTION 1.55 0.78 REF 0.40 TYP 0.040 REF 0.50 TYP Ø0.129 6 PL 0.900 TYP D3999-5F FLAT PATTERN

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S 040
2) FINISH: N/A
2) TOLEDANGE DEP BART 001010 1010

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs

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DESIGN	ASI	DART AEROS	PACELID					
DRAWN	AL I		HAWKESBURY, ONTARIO, CANADA					
CHECKED.	B	DRAWING NO.	REV A					
MFG. APPR.	居	D3999	SHEET 7 OF 12					
APPROVED	10	TITLE	SCALE					
DE APPR.	-#	BAFFLE	NTS					
DATE 10.0	2.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPOSITION OF SUPPLED ON THE CURRENT CONTINUE THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPOSITION TO ANY OTHER PERSON WITHOUT						

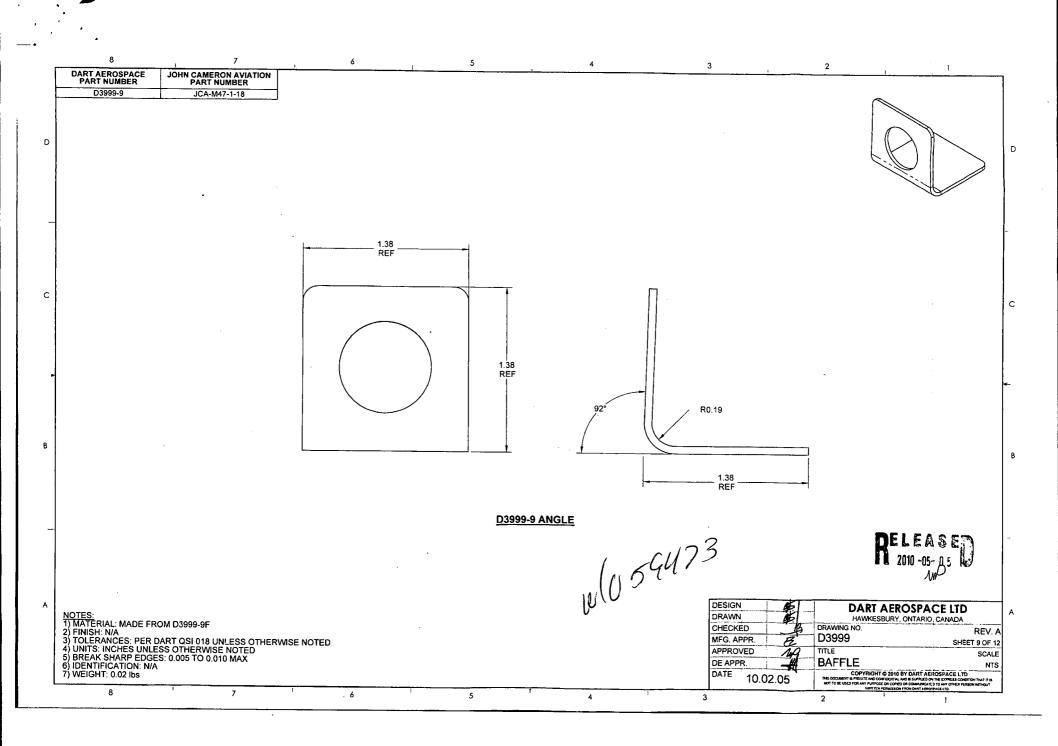
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W/O:	T		WO	RK ORDER CHANGE	S				1
DATE	STEP	PR	NGE	Ву	Date	dty	Approval Chief Eng / Prod Mgr	Approva QC Inspect	
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			R NON-CONFORMAN						
DATE	STEP	Description of NC		Corrective Action Section B		Verificat	ibn	Approval	Approva
	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspect
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DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D3999-7 JCA-M47-1-17 D D - 0.59 0.59 1.77 Ø0.157 **D3999-7 CORNER** NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF DART SPEC M6061T6S.080 DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN CHECKED DRAWING NO. REV. A 2) FINISH: NY. 3 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A 7) WEIGHT: 0.01 lbs D3999 MFG. APPR. SHEET 8 OF 12 TITLE APPROVED SCALE DE APPR. **BAFFLE** NTS COPYRIGHT 6 2010 BY DART AEROSPACE LTD
THIS COCUMENT IS PRIVATE AND COMPOSITION THAT IT IS
NOT TO BE USED FOR ANY INVENDED OF COMPOSITION THAT IT IS
NOT TO BE USED FOR ANY INVENDED OF COMPOSITION TO NAME OTHER PERSON WITHOUT
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W/O:			WORK ORDER CHANGES						3 3	
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DATE	STEP	Description of NC	Corrective Action Section B			Verifica	ton	Approval	Approval	
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8 . 5 . D Ø0.768 GRAIN DIRECTION £ 1.38 who 59413 BEND LINE 0.68 0.063 REF 1.29 REF D3999-9F FLAT PATTERN NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF DART SPEC M6061T6S0.063 DESIGN DART AEROSPACE LTD 2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D3999 MFG. APPR SHEET 10 OF 12 APPROVED TITLE

10.02.05

DE APPR.

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**BAFFLE** 

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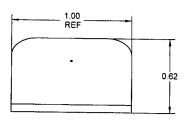
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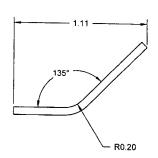
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section			QC Inspect
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JOHN CAMERON AVIATION PART NUMBER DART AEROSPACE PART NUMBER D3999-11 JCA-M47-1-19

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**D3999-11 EARTH TAB** 

WILL 59473
RELEASE

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NOTES:
1) MATERIAL: MADE FROM D3999-11F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

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DESIGN	<b>8</b> 5	DART AEROSPACE LTD						
DRAWN	45		HAWKESBURY, ONTARIO, CANADA					
CHECKED		DRAWING NO.	REV. A					
MFG. APPR.		D3999	SHEET 11 OF 12					
APPROVED	10	TITLE	SCALE					
DE APPR.		BAFFLE	NTS					
DATE 10.0	2.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIMATE AND COMPERTUL AND IS SUPPLED ON THE EXPRESS CONSTITUTION THAT IT IS NOT TO BE USED YOUR ANY PURPOSE ON COMPENSOR COMMINISTRATION ON YOUR POSSON WITHOUT WHITTEN FORESSOR FROM THE RESPONSE OF						

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DATE	STEP	Description of NC		Corrective Action Section B		Verifica			Approval	Approval	
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Ø0.125 2 PL 0.56 1.00 GRAIN DIRECTION 0.22 TYP R0.20 TYP 0.25 0.063 REF BEND LINE 0.52 REF

D3999-11F FLAT PATTERN

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3999 MFG. APPR. SHEET 12 OF 12 APPROVED TITLE BAFFLE DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
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2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NIA
7) WEIGHT: 0.01 lbs

8

NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF DART SPEC M6061T6S.063

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W/O: WORK ORDER CHANGES											
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DATE	STEP	Description of NC Section A	Corrective Action Section B		on B	B Verifica		Approval	Approval		
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Varification		
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